

Date: Wednesday, 10/25/2006 11:13:28 AM
 User: Kim Johnston

Process Sheet

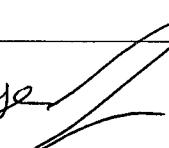
Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET ASSEMBLY	
Job Number	: 29155		Part Number	: D2803041	
Estimate Number	: 11029		Drawing Number	: D2803 REV B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 10/25/2006	S.O. No. : N/A	Drawing Revision	: B	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 11/1/2006	
Previous Run	: 27282		Qty:	3 Um: Each	
Written By					
Checked & Approved By					
Comment	: EST F 05.03.30 MS21043-3 was MS21042L3		KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D28031	STA 84 Bracket
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) STA 84 BRACKET Pick: Qty Part Number Description Batch 1 D2803-1 Bracket
2.0	D28051	Stop
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) STOP Pick: Qty Part Number Description Batch 1 D2805-1 Stop
3.0	D2809	Bushing
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Bushing Pick: Qty Part Number Description Batch 1 D2809 Bushing Press D2805-1 into arm as per Dwg D2803
4.0	QC5	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/10/30	4.0	QCS, not 2. Permanent change					 06/10/30

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/25/2006 11:13:28 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 29155

Part Number: D2803041

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	POWDER COATING	POWDER COATING M101575
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION mf 06/10/30
7.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Press D2809 into arm as per Dwg D2803 mf 06/10/31
8.0	AN3C16A	Bolt Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s) Bolt Pick: Qty Part Number Description Batch 2 AN3C16A Bolt m101064 mf 06/10/31
9.0	MS210433	Nut Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s) Nut Pick: Qty Part Number Description Batch 2 MS21043-3 Nut m1010390 mf 06/10/31
10.0	NAS1515H3	Washer Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s) Washer Pick: Qty Part Number Description Batch 4 NAS1515H3 Washer m100993 A/R LPS-3 Corrosion Spray m101472 Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2803 mf 06/10/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod.Mgr	Approval QC Inspector
06/01 31	11	Applied LPS Hardcoat on washer & nut <u>m 17045</u>	M.F.	06/01 31	3	<i>VB</i> <i>06/01/31</i>	<i>J</i> <i>06/10/30</i>

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/18/31
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

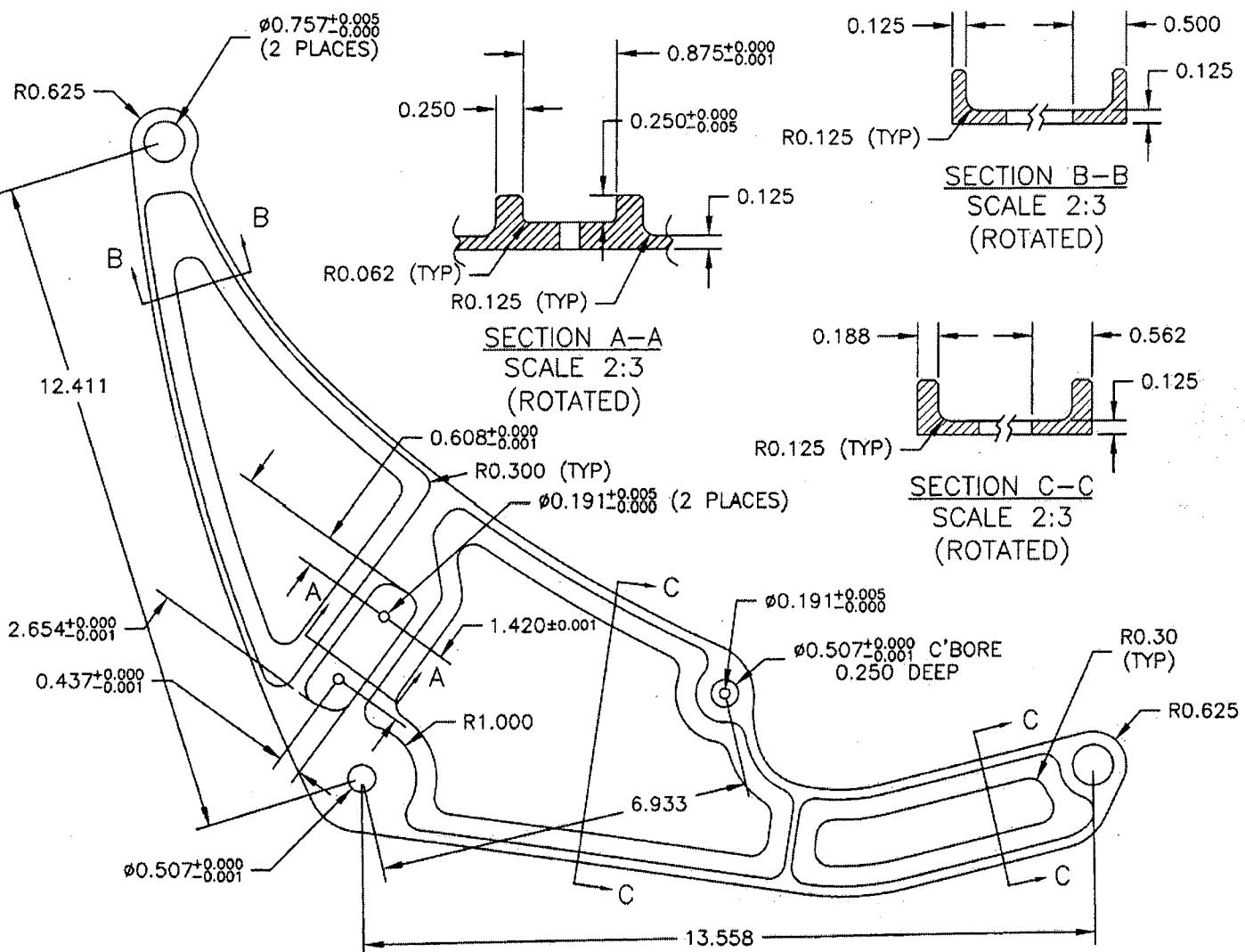
NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2803	REV. B SHEET 1 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	

RELEASED

05.03.11 *[Signature]*



D2803-1 BRACKET (SHOWN), D2803-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 – 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

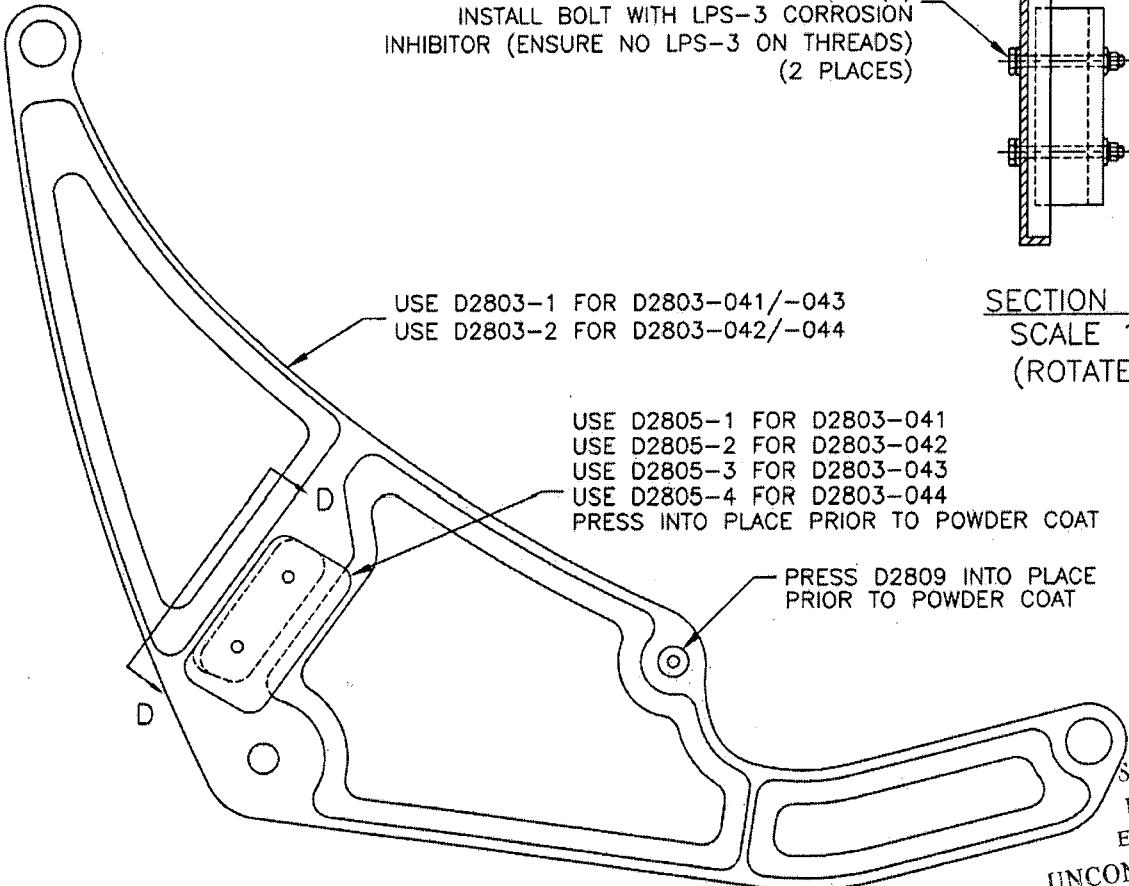
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NO. 29155

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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



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WORK ORDER

RELEASED *Z9155*
05-03-01 *[initials]*

D2803-041/-043 BRACKET ASS'Y (SHOWN),
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3